Monday, April 26, 2010 11:12:34 AM



Page 1

Item ID: D4021-5 Accept Setup Start **Revision ID:** Stop Blanking Plate Item Name: Start Date: **Start Oty: 12.00** 4/26/2010 **Cust Item ID: Required Date: 4/30/2010** Req'd Qty: 12.00 **Customer:** Reference: Start Run Process Plan: MF Date: 0-4-86. Tooling: Approvals: Date: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Accept Reject Draw Plan Reject Insp. **Work Center ID** Description Qty **Run Hours** Number Rev. Qty Number Stamp Code Draw Nbr **Revision Nbr** D4021 В 100 0.00 10-4-29 Waterjet 0.00 Memo FLOW CNC Waterjet Cut as per dwg D4021 304.062 Prog Rev: Dwg Rev: Deburr as required 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1510 -H- 29 0.00 Memo Quality Control

<b>Dart Aerospace</b>	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROC	EDURE CH	ANGE		Ву	Date Q	Approval Chief Eng / Prod Mgr	Appròval QC Inspector		
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Part No	•	PAR #:	_ Fault Cat	egory:	_ NCR	: Yes N	lo DQA: _	Date: _			
Resolution:			_ Dispositi	Disposition: QA: N/C Closed: Da							
NCR:				DER NON-CONFORM							
DATE	STED	Description of NC	Corrective Action Section B			Verification		n Approval	Approval		
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector		
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Monday, April 26, 2010 11:12:34 AM

D4021-5

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Blanking Plate

**Start Date:** 4/26/2010 **Required Date: 4/30/2010** 

**Start Oty: 12.00** 

Rea'd Otv: 12.00

Cust Item ID:

**Customer:** 

Draw

Number

Reference:

Ap	prova	ls:
	P . O	•••

Process Plan: Date:

Tooling:

Date: \_\_\_\_\_

Run Start

Reject

Oty

Accept

**Qty** 



OC:

Date:

**SPC (Y/N):** 

Set Up/

0.00

**Run Hours** 

Date:

Draw

Rev.

Plan

Code

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ Work Center ID

120



**Quality Control** 

Operation

Description

White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel

START: 7:15AM

Memo Temp 4000F

=> Al 10/05/03

X17 \_ Ø\_

130

Powdercoat Powder Coating

OC8- Inspect parts - second check

Memo

Fin: 7:45am

135

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BL 10-5-3

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W/O:			WC	ORK ORDER CHANG	ES				<b>3</b> 1
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	7.00								
		PAR #:	Fault Cate	gory:	_ NCR: Yes	A:	Date:		
			Disposition: QA						
NCR:		1	WORK ORDI	ER NON-CONFORMA	ANCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	erification Approva		Approval
	0.2.	Section A	Initial Action Des Chief Eng Chief E		Sign & Date	k Section C		Chief Eng	QC Inspector
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### Work Order ID 58140

Monday, April 26, 2010 11:12:34 AM



Page 3

Item ID:

D4021-5

Accept



Setup Start



**Revision ID:** 

Item Name:

Required Date: 4/30/2010

Blanking Plate

**Start Date:** 

4/26/2010

**Start Qty: 12.00** Req'd Qty: 12.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Date: Date: Run

Start

Stop

Stop



Sequence ID/ Work Center ID

140

Packaging

Packaging

Operation Description

Date: \_\_\_\_\_

Identify as per dwg & Stock Location

Memo

Set Up/ **Run Hours** 

0.00

0.00

Draw

Number

; 1

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number

Stamp

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Dart .	Aer	osp	pace	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	L			
			Disposition: QA: N/C Closed: Date									
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DATE	STEP	Description of NC	Initial	Corrective Action Sect Action Description	ion B	gn & Section C		Approval	Approval QC Inspector			
		Section A	Chief Eng	Chief Eng	Date			Chief Eng				
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### **Picklist Print**

Monday, April 26, 2010 11:12:34 AM

Work Order ID: 58140

Parent Item:

D4021-5

Parent Item Name:

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC

DD 10.04.20 verified by:EC

Start Date: 4/26/2010

Required Date: 4/30/2010

**Start Qty: 12.00** 

Required Qty: 12.00

Component Item ID/ M304S16GA

Replacement Mfg/

Purchased

Bin Primary Last

Route

Unit of

Qty on

Remaining

Qty

Date

Status

304/316 Sheet .063

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111323

114467

177.9848 0

177.9848

114467



1810-4-09

Blanking Plate

per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB

No

100

sf

177.9848 0.7857

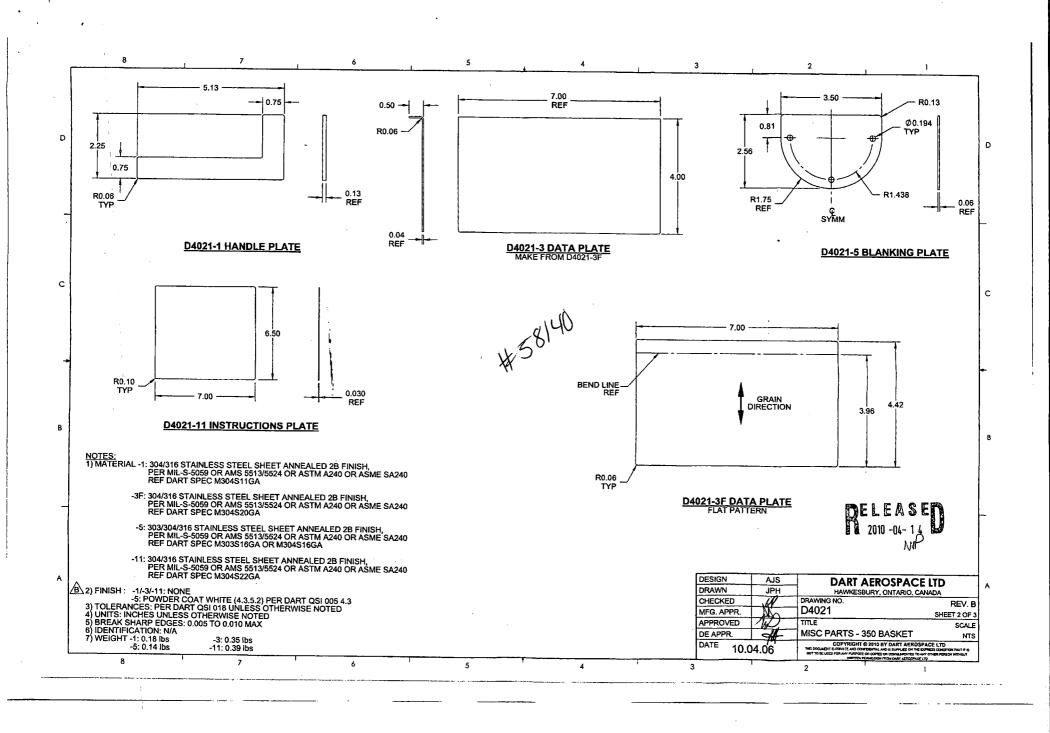
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W/O: WORK ORDER CHANGES							€ 4			
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STED	Description of NC Corrective Action			VA			Verification Approva		Approval
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	!	Sign & Date	Section C		Chief Eng	QC Inspector	
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DART AEROSPACE LTD	Work Order:	58140
Description: Blanking Plate	Part Number:	D4021-5
Inspection Dwg: D4021 Rev: B		Page 1 of 1

	FIRST A	ARTICLE IN	ISPECTION	ON CHE	CKLIST		
	X	First Artic	cle _	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		mments
Ø0.194	+0.005/-0.001	, 197	<b>A</b>				
3.50	+/-0.030	3,505	8				
2.56	+/-0.030	7.563	*				
0.81	+/-0.030	,811	*				
0.060	+/-0.010	.062	*				
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	10-4-29	Date:	10/04/0	9 [		Date:	
v Date (	Change		,	<u></u>	Rev	ised by $_{\Lambda}$	Approved
10.04.20	Vew Issue				KJ	OXX	11/

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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No		PAR #:	Fault Cate				NCR: Yes No DQA: Date:					
	Res	solution:	Dispositio	n:	_ QA: N/C (	closed:		Date: _	<del></del>			
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)						
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			- Cian P Verifica		Approval				
		Section A	Chief Eng	Action Description Chief Eng	Date		ection C	Chief Eng	QC Inspector			
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W/O:		WORK ORDER CHANGES								, ,
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	Resolution: Disposition:									
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DATE	STEP Description of Section A	Description of NC	Corrective Action Section B				Verification		Approval	Approval
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